



Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 9577  
Fax: 613 632 1053

## PURCHASE ORDER

Purchase Order ID PO12546

Purchase Order Date 9/10/10

PO Print Date 9/10/10

Page Number 1 of 1

Order From :

MAGNA STAINLESS  
5775 RUE KIERAN  
ST LAURENT, QC H4S 0A3  
CA

VC-MAG002

Contact Name

Vendor Phone 800 363 6646

Vendor Fax 514 339 1105

Vendor Account Nbr

Buyer

Chantal Lavoie

Requisition Nbr

Tax Resale Nbr 10127-2607

Terms Net 30

Currency CAD

FOB

Ship To :

DART AEROSPACE LTD 1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
CANADA

**FAXED**  
C. Lavoie

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	M303R1.000	303 Round Bar 1.00	9/15/10 Yes	24.00 f	Yours ppd	\$6.6667	\$160.00
Special Inst:			MATERIAL: 303 SS ROUND BAR NOTE: AISI 304/316 NOT ACCEPTABLE				
2	M304S16GA C21019117	304/316 Sheet .063	9/15/10 Yes	160.00 sf	Yours ppd	\$5.2500	\$840.00
Special Inst:			MATERIAL: AISI 304/316 SS SHEET ANNEALED 2B FINISH AS PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240				
3	M6061T6A1.000W.125 C21019117	6061T6 ANGLE 1.00 x 1.00 x .125W	9/15/10 Yes	40.00 f	Yours ppd	\$0.6000	\$24.00
Special Inst:			MATERIAL: 6061-T6 OR T6510/T6511 ALUMINUM ANGLE AS PER AMS-QQ-A-200/8				
MATERIAL CERTIFICATION REQ'D UPON DELIVERY			POSITIVE RECALL EFFECTIVE 09-17 AUTH C21019117 RELEASED 11 DATE 10-09-24 PO Total: \$1,024.00				

Change Nbr: 1

Change Date: 9/10/10

No substitution or deviation without  
consent.  
Certificate of Conformity or Material  
Certification required when applicable



# INSPECTION CERTIFICATE

CERTIFICATE NO.: SK-99040

CUSTOMER: MAGNA STAINLESS INC(DIV OF CANADIAN SPECIALTY METALS INC.)

VOICE NO.: SSCAE40302TE9

CREDIT NUMBER: 1700625

DESCRIPTION: STAINLESS STEEL SHEETS

JUN 01 2010

P/L NO.	SIZE	PCS	N.W. (KG)	SPEC	HEAT NO.	REFERENCE NO.
59	0.9mm (20ga) X 1219mm (48") X 3048mm (120")	86	2256	304 / 2B	A0639-2010	F8055
60	0.9mm (20ga) X 1219mm (48") X 3048mm (120")	86	2259	304 / 2B	A0639-2010	F8055
61	1.2mm (18ga) X 1219mm (48") X 2438mm (96")	87	2428	304 / 2B	B7113-1020	F8209
62	1.2mm (18ga) X 1219mm (48") X 3048mm (120")	64	2232	304 / 2B	B7113-1020	F8209
63	1.2mm (18ga) X 914mm (36") X 3048mm (120")	51	1342	304 / 2B	YU256274	93S51062B
64	1.5mm (16ga) X 1219mm (48") X 2438mm (96")	70	2433	304 / 2B	A0587-3030	F8139
65	1.5mm (16ga) X 1219mm (48") X 2438mm (96")	70	2434	304 / 2B	A0587-3030	F8139
66	1.5mm (16ga) X 1219mm (48") X 2438mm (96")	70	2435	304 / 2B	A0587-3030	F8139
67	1.5mm (16ga) X 1219mm (48") X 2438mm (96")	58	2013	304 / 2B	A0587-3030	F8139
68	1.5mm (16ga) X 1219mm (48") X 3048mm (120")	51	2218	304 / 2B	A0587-3030	F8139

## Chemical Composition

## Mechanical Test

P/L NO.	C	Si	Mn	P	S	Ni	N	Cr	Mo	Y.S.(0.2%) N/mm2	T.S. N/mm2	Elongation %	HRB
59	0.048	0.526	1.139	0.031	0.006	8.136	0.0590	18.0510	-	283	640	54.3	80.6
60	0.048	0.526	1.139	0.031	0.006	8.136	0.0590	18.0510	-	283	640	54.3	80.6
61	0.047	0.447	1.207	0.032	0.004	8.017	0.0500	18.1500	-	295	629	54.7	82.0
62	0.047	0.447	1.207	0.032	0.004	8.017	0.0500	18.1500	-	295	629	54.7	82.0
63	0.043	0.520	1.110	0.030	0.001	8.100	0.0250	18.1300	-	306	685	51.0	87
64	0.046	0.421	1.183	0.029	0.005	8.133	0.0560	18.1880	-	303	643	53.3	85.7
65	0.046	0.421	1.183	0.029	0.005	8.133	0.0560	18.1880	-	303	643	53.3	85.7
66	0.046	0.421	1.183	0.029	0.005	8.133	0.0560	18.1880	-	303	643	53.3	85.7
67	0.046	0.421	1.183	0.029	0.005	8.133	0.0560	18.1880	-	303	643	53.3	85.7
68	0.046	0.421	1.183	0.029	0.005	8.133	0.0560	18.1880	-	303	643	53.3	85.7

Remark: 1. We hereby certify that the products described herein have been manufactured and tested with satisfactory results in accordance with the requirement of the above material specification.

2. As per ASTM A240/480 standard.

3. The material described above has been detected with free irradiation.

Q.C. MANAGER

Jai

# MAGNA

Magna Stainless

5775 Kieran St. Saint-Laurent, Quebec H4S 0A3  
Phone: (514) 339-1211 Watts: 1-800-363-6646 Fax: (514) 339-1105



## PACKING LIST

Page 1 of 1

I032442

SOLD TO:  
DART AEROSPACE LTD  
1270 ABERDEEN STREET  
HAWKESBURY, ON K6A 1K7

SHIP TO:  
DART AEROSPACE LTD  
1270 ABERDEEN STREET  
HAWKESBURY, ON K6A 1K7

MAGNA  
Qc 6

SPECIAL INSTRUCTIONS

\*\*\*\*\*STOCK\*\*\*\*

Contact: C. LAVOIE

Ship Terms: PREPAID

MTR:Y

Currency		Sales Person	Customer Phone	Customer Fax	Customer PO	
CANADIAN DOLLARS		DAVE MC VETY	(613) 632-5200	(613) 632-1053	12546	
Sales Order	Terms	Ship Via		Date Ordered	Date Required	Date Shipped
W035566	NET 30 DAYS	NIR:R-557065-1		09/16/10	09/17/10	09/17/10

Ordered	Back Ordered	Unit	Description	Bundle #	Heat #	Shipped
2		PC	ALUMINUM ANGLES AAN 6061 T6 1" x 1" x 1/8" x R/L 20' 12 LB / 2 PC	L042208	2BM307	2
5		PC	STAINLESS SHEET SSH 304 2B 16ga x 48" x 96" 420 LB / 5 PC	L040896	A0587-3030	5
Bundles: 1		Skids: 1		Approx Weight:		432 LB

Received by: \_\_\_\_\_

Date: \_\_\_\_\_

Signature: \_\_\_\_\_



## Receiving Report

Date: 10/9/17

Batch No: M 115688

Supplier: Magna

Dart P/O: 12546

Packing Slip: Yes ☒ No ☐  
 Invoice: Yes ☐ No ☒  
 Receipt: Cash ☐ Cr ☐

Release Note Attached: Yes ☒ No ☐ N/A ☐  
 Waybill Attached: Yes ☐ No ☒ N/A ☐  
 Shipment Complete: Yes ☒ No ☐ N/A ☐  
 QC6 Inspection ☒ N/A ☐  
 Work Order 106724 N/A ☐

### Discrepancies

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments
303D 1"		24	0	0	24	

Initials of receiver (if shipment OK) Level 12 CZ

Production/Admin: 10/9/20  
 Date  
 Received/Costing [Signature]  
 Initial

Location \_\_\_\_\_

DART AEROSPACE LTD		Work Order: 62302
Description: Door Oxidizer		Part Number: D4108-3
Inspection Dwg: D4103-3 Rev: A		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø 1.128	+ .005 - .001	1.128	x		V IB 02	
Ø .375	+ .006 - .001	.375	#		V	
Ø .386	+ .006 - .001	.386	x		V	
S.85	± .030	S.851	x		V	
S.60	± .030	S.604	x		V	
.80	± .030	.800	x		V	
.400	± .010	.401	x		V	
.490	± .010	.488	x		V	
.60	± .030	.600	x		V	
.38	± .030	.380	x		V	
.375	± .010	.376	x		V	
1.78	± .030	1.781	x		V	
.254	± .010	.254	x		V	
.508	± .010	.508	x		V	
3.50	± .030	3.499	x		V	
.87	± .030	.871	x		V	
.25	± .030	.251	x		V	
.25	± .030	.250	x		V	
.73	± .030	.731	x		V	
2.13	± .030	2.129	x		V	
.71	± .030	.709	x		V	
2.63	± .030	2.629	x		V	
6.48	± .030	6.477	x		V	
.063	± .010	.059	x		V	

Measured by: IB
Date: 10-9-07

Audited by: S
Date: 10/09/07

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





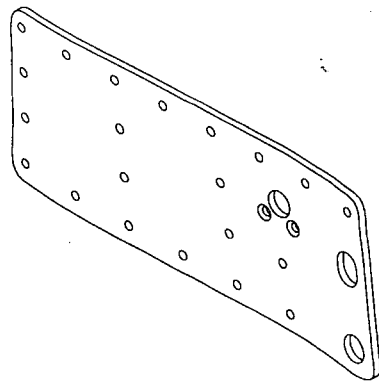
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

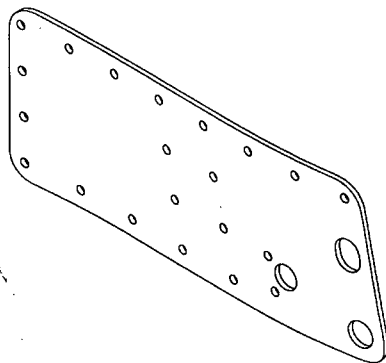
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

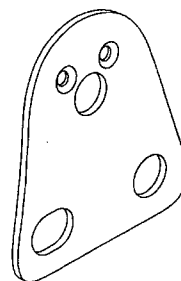


**D4108-1 LEFT PASS DOOR DOUBLER**

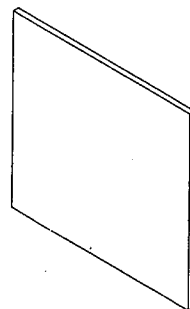


**D4108-3 RIGHT PASS DOOR DOUBLER**

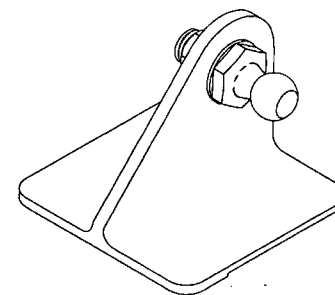
*#62302*



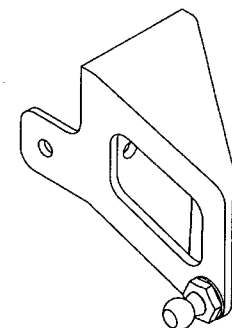
**D4108-5 SMALL RIGHT DOOR DOUBLER**



**D4108-11 TEMPLATE**



**D4108-047 SILL BRACKET ASSEMBLY**



**D4108-049 LITTER DOOR FITTING ASSEMBLY**

**RELEASED**  
2010-09-23  
AM

REV.	DESCRIPTION	BY	DATE
A	NEW ISSUE	JPH	10.07.20
DESIGN	JPH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA DRAWING NO. <b>D4108</b> TITLE <b>DOUBLERS &amp; FITTINGS</b> SCALE <b>NTS</b>	
DRAWN	JPH		
CHECKED	<i>[Signature]</i>		
MFG. APPR.	<i>[Signature]</i>		
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>	REV. A SHEET 1 OF 7	
DATE	10.07.20	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Friday, September 24, 2010 3:27:30 PM

Page 1

Work Order ID: 62302

Parent Item: D4108-3

Parent Item Name: Door Doubler, Right





Start Date: 9/27/2010

Required Date: 10/4/2010

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP Rev:A 10.09.24 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA 		Purchased	No			100	sf	153.2400	0.1183	0.373579	148.59		
304/316 Sheet .063											1810-9-27		

## Location

## Loc Qty

## Loc Code

MAT	146.7	
111323	0	
115688	146.7	
MAT20	6.54	
115440	6.54	

115688

⑤

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 62302**

Friday, September 24, 2010 3:27:31 PM



Page 3

Item ID: D4108-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Door Doubler, Right

Start Date: 9/27/2010 Start Qty: 3.00



Cust Item ID:

Required Date: 10/4/2010 Req'd Qty: 3.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150



Packaging

Identify as per dwg & Stock Location: 129

0.00

Memo

0.00

10.10.12 (S)

Packaging

160



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10.10.1210-10-13 (S)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 62302

Friday, September 24, 2010 3:27:31 PM



Page 2

Item ID: D4108-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Door Doubler, Right

Start Date: 9/27/2010 Start Qty: 3.00



Cust Item ID:

Required Date: 10/4/2010 Req'd Qty: 3.00

Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120



QC

Quality Control

QC8- Inspect parts - second check

0.00

Memo

0.00

8/10/10/12/27  
to PW A

(X5)

130



Small Fab

Small Fab

Memo

0.00

0.00

1- Use press to start forming D4108-3 as per dwg using DT9649. Then finish the shape of D4108-3 by hand.

JB 10/10/05

(5)

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

0.00

Memo

\*\*\*Use DT9649 for inspection\*\*\*

8/10/10/06

(X5)  
-3



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 62302

Friday, September 24, 2010 3:27:31 PM



Page 1

Item ID: D4108-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Door Doubler, Right

Start Date: 9/27/2010 Start Qty: 3.00



Cust Item ID:

Required Date: 10/4/2010 Req'd Qty: 3.00



Customer:

Reference:

Approvals:

Process Plan: mf

Date: 10-9-24

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D4108

A

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

304 . 063

1-Cut as per Dwg

Dwg Rev: A

Prog Rev: 2

2-Deburr if necessary

10-9-27

⑤

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

10-9-27

MATERIAL CERTIFICATION  
REQ'D UPON DELIVERY  
09/10/10